

Date: Tuesday, 5/23/2006 8:36:36 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABLE GUARD
 Job Number : 27210
 Estimate Number : 12410
 P.O. Number : N/A Part Number : D34993
 This Issue : 5/23/2006 S.O. No. : N/A Drawing Number : D3499 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 27043 Material : N/A
 Due Date : 6/5/2006 Qty: 8 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06-05-23
 Comment : Est Rev. New Issue 06-05-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MUHMWB625 UHMW .625 Black Tivar 1000



Comment: Qty.: 1.1351 sf(s)/Unit Total: 9.0804 sf(s)

UHMW .625 Black Tivar 1000

Batch: M101046

M 06 05 31

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3499

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

M 06 05 31

(8)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 05 31

(8)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment:

HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA636 Rev: AA & Dwg D3499 Rev: A


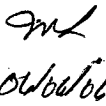


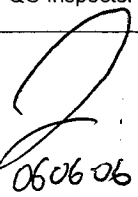
M 06/06/01


7

2-Deburr per dwg D3499

P10
Date

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/06	4	-1 piece scrap. Found a deep gouge in middle top section of the part. .5 Long .125 wide. .102 deep. Reason unknown. Could have been hit with the corner of a metal sheet on the rack.	 Initial	Scrap & destroy part. mark unacceptable	 Sign & Date 06/06/06	 Verification 06/06/06	 Approval Design Mgr	 Approval QC Inspector 06/06/06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/08/09

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:36:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27210

Part Number: D34993

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/06/01

7

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/06/06

27

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST76*

AP 06/06/01

(7)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/08

(7)

Job Completion



U 06.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

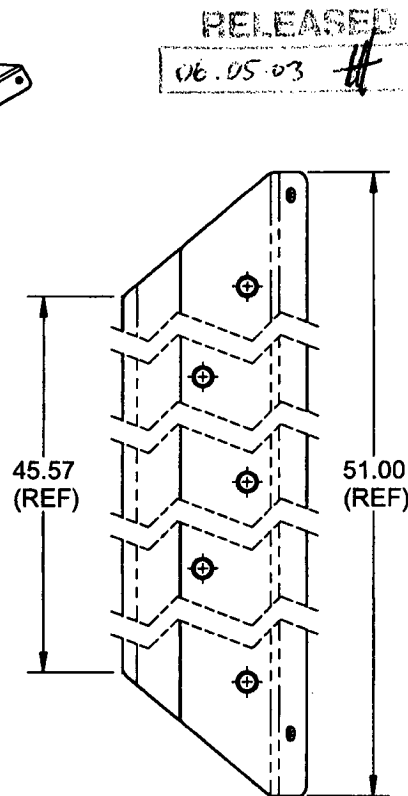
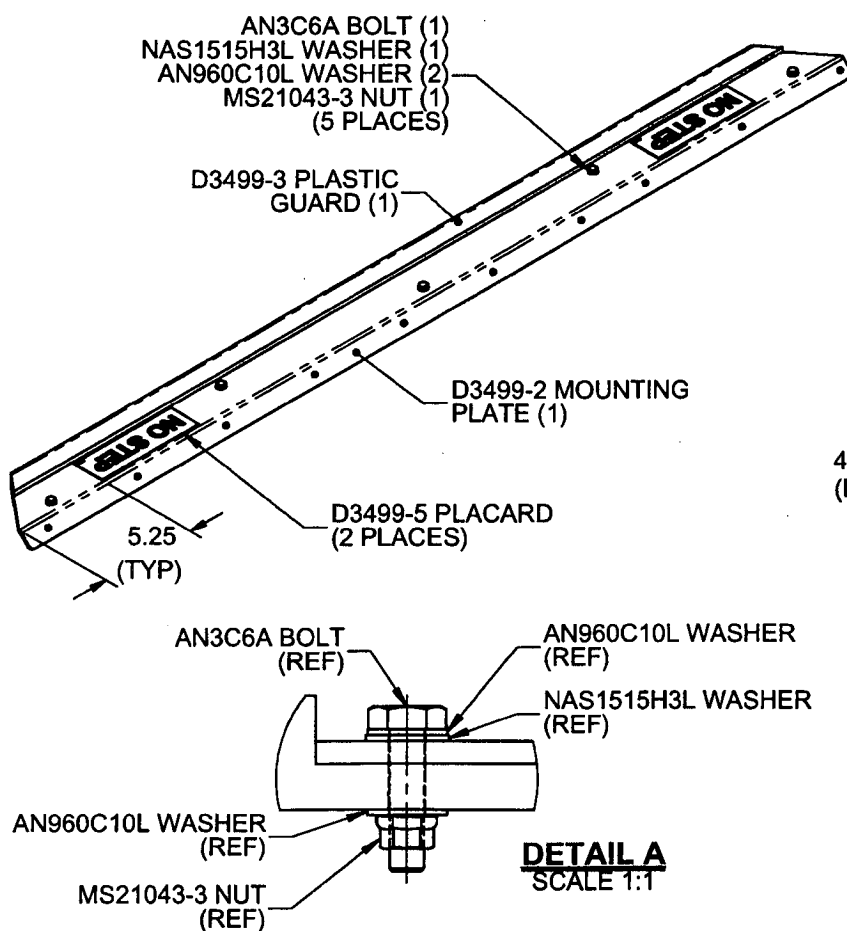
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

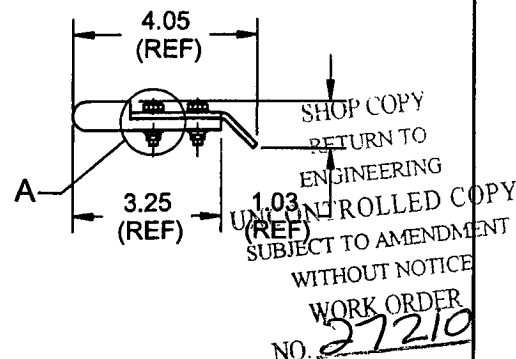


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. A SHEET 1 OF 4
DATE 06.04.11		TITLE CABLE GUARD	SCALE 1:4
A	06.04.11	NEW ISSUE	



D3499-042 CABLE GUARD ASSEMBLY

QTY -042	P/N	DESCRIPTION
X	D3499-042	CABLE GUARD ASSEMBLY
1	D3499-2	MOUNTING PLATE
1	D3499-3	PLASTIC GUARD
2	D3499-5	PLACARD
5	AN3C6A	BOLT
10	AN960C10L	WASHER
5	MS21043-3	NUT
5	NAS1515H3L	WASHER



NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

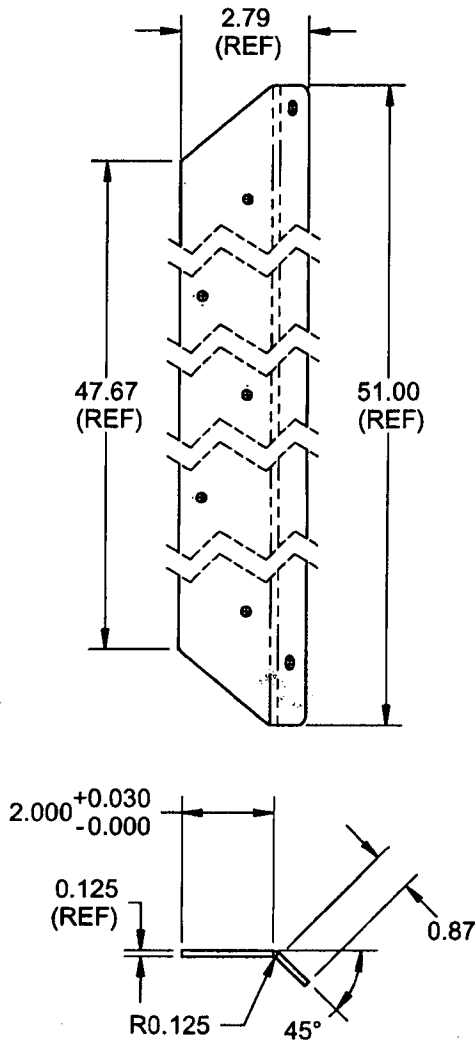
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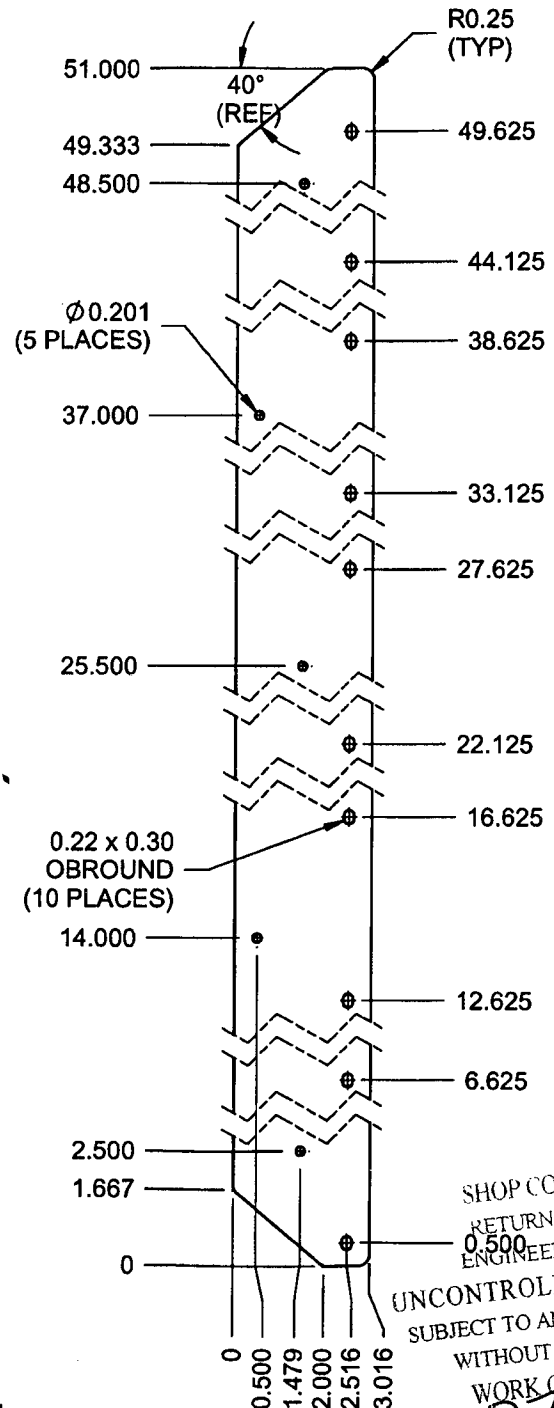
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. A SHEET 2 OF 4
DATE 06.04.11		TITLE CABLE GUARD	SCALE 1:4

RELEASED

06-15-02 *[Signature]***D3499-2 MOUNTING PLATE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3499-2F MOUNTING PLATE FLAT PATTERN**

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **27210**

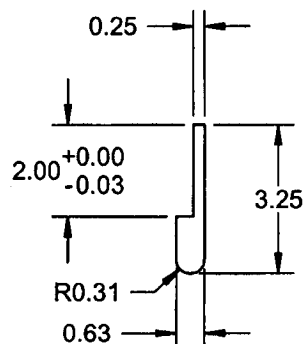
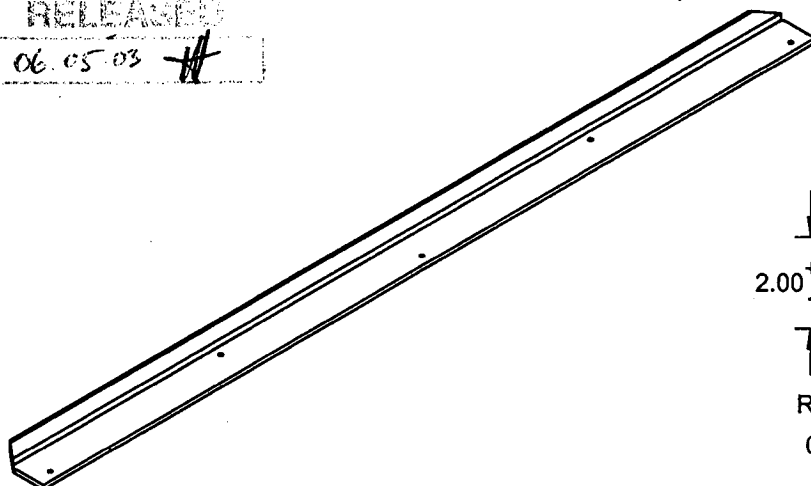
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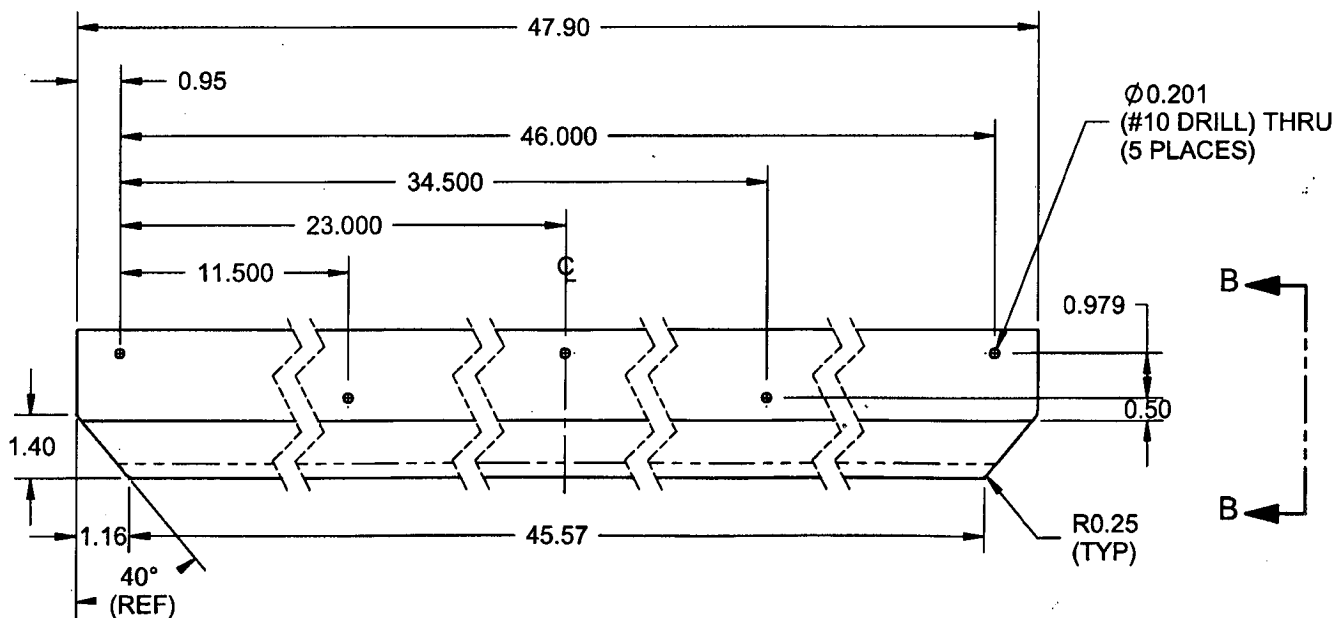


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DATE 06.04.11		TITLE CABLE GUARD	SCALE 1:4

RELEASED
06.05.03 *[Signature]*



VIEW B-B



D3499-3 CABLE GUARD

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (MUHMWB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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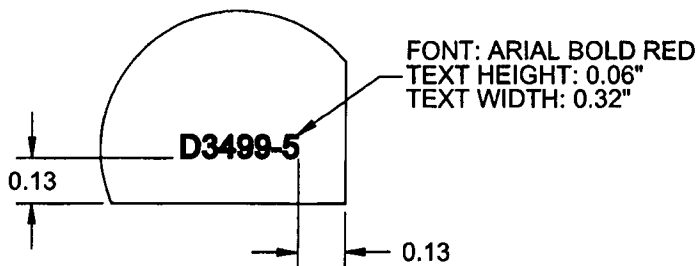
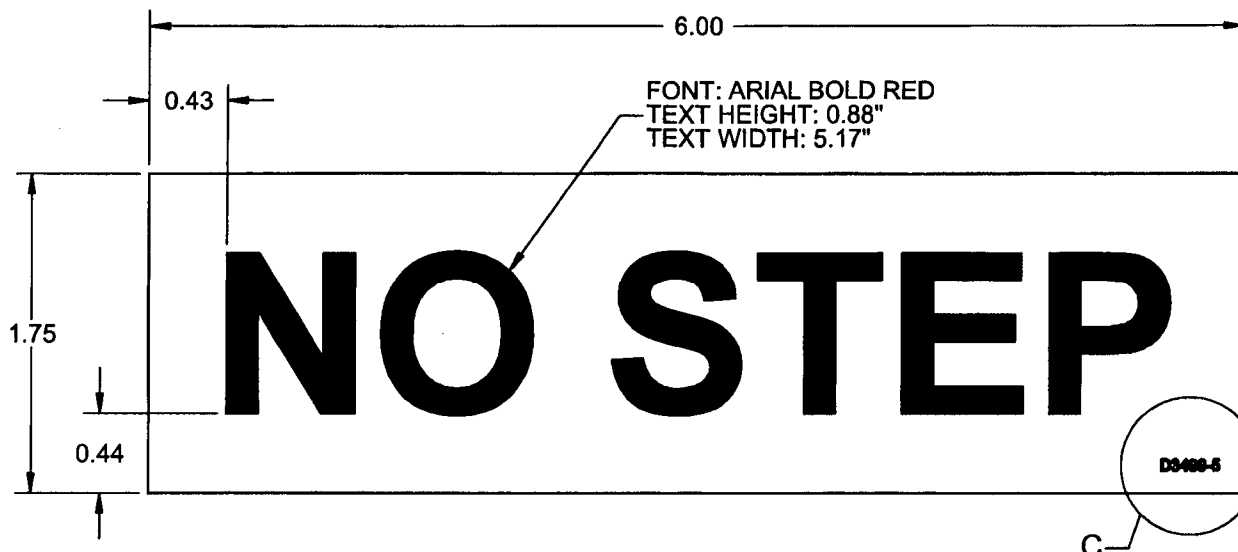
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DATE 06.04.11		TITLE CABLE GUARD	SCALE 1:1

RELEASED
06-05-03 *[Signature]*



DETAIL C
SCALE 1:2

D3499-5 PLACARD

NOTES:

- 1) MATERIAL: RED LETTTERS ON WHITE ADHESIVE BACK VINYL
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031. SIZE IS 6.00" LONG" x 1.75" WIDE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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